

Date: Wednesday, 1/25/2006 1:20:03 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET LID ASSEMBLY		
Job Number	: 25614B					
Estimate Number	: 10207					
P.O. Number	: N/A			Part Number	: D2989043	
This Issue	: 1/25/2006 S.O. No. : N/A			Drawing Number	: D2989 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: B	
Previous Run	: 25613B			Material	: N/A	
Written By	: <u>SEE COMMENT BELOW</u>			Due Date	: 2/20/2006	
Checked & Approved By	: <u>OK 06.01.27</u>			Qty:	1 Um: Each	
Comment	: Est Rev: Removed D2989-041 05-11-03			JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31821	Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part number	Description Batch
		2 D3182-1	Hinge <u>B25240</u>
			<u>AA 06/02/21</u>
2.0	D34423	Shim	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part number	Description Batch
		2 D3442-3	Shim <u>B23545</u>
			<u>AA 06/02/21</u>
3.0	M304EX07516F	Expanded Metal Flat Stai	
		Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s)	
		Pick:	
		Qty Part number	Description Batch
		15sf M304EX0.75-16F	Expanded Metal <u>M100071</u>
			<u>AA 06/02/21</u>
4.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s)	
		3/4" x 3/4" x 0.063" wall 304/316 SStubing.	
		Batch: <u>M100023</u>	<u>AA 06/02/21</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 25614B

Part Number: D2989043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

Note: D2989-3/-4 On -041 Bom

MM 06/02/27

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

6.0 QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD 06-02-27

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

FC 06 03 02

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



RR 06-03-03

Comment: Inspect Powder Coat

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

QD 06/03/06

Job Completion



W 06/03/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

RELEASED

05-08-19

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
1		D2989-1	STRUT
1		D2989-2	STRUT
1		D2989-3	STRUT
1		D2989-4	STRUT
2		D2989-5	STRUT
2		D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

NOTES:

1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236

2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F) *INT ROLLED COPY*

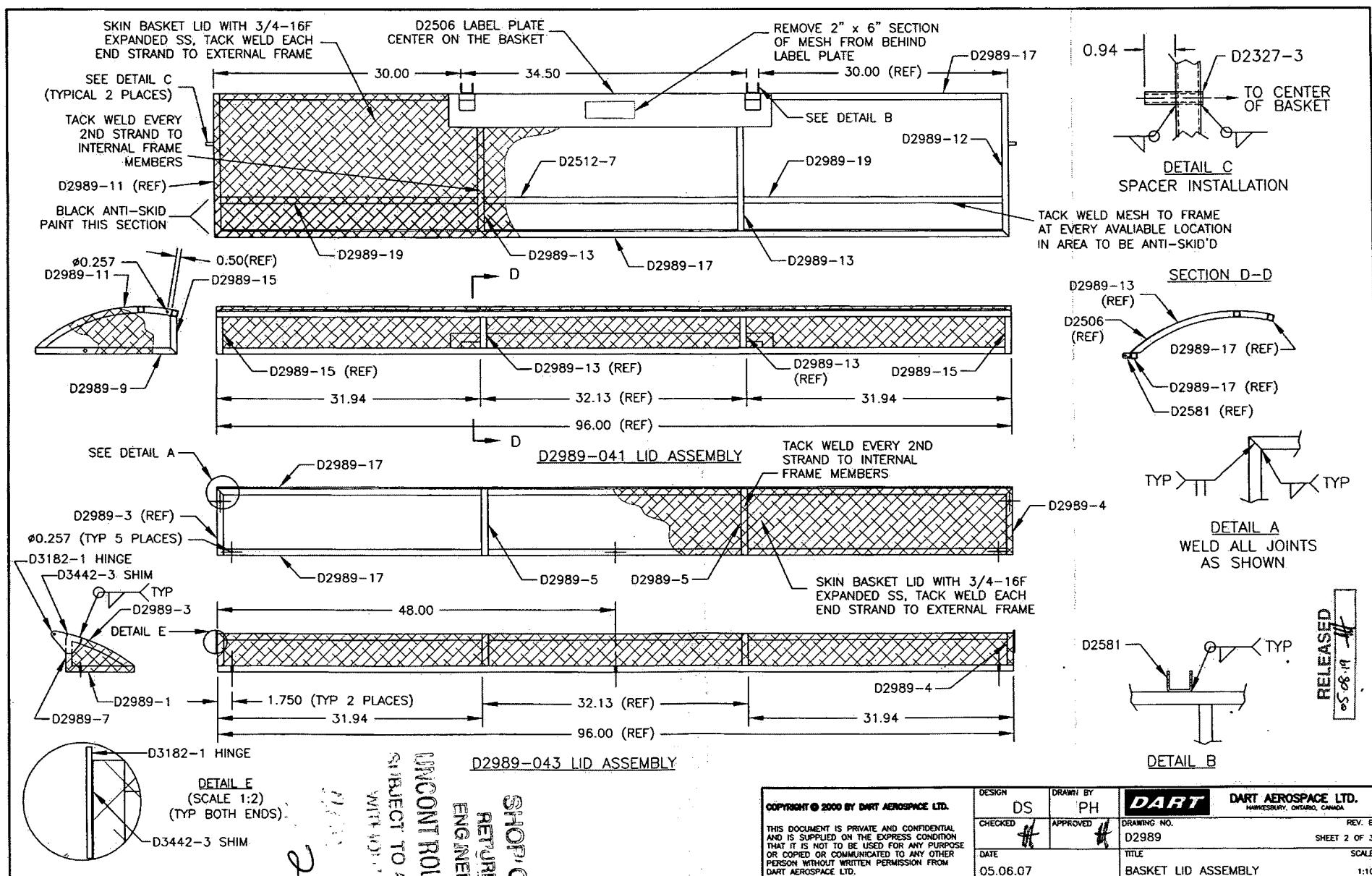
3) WELD PER DART QSI 004

4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3. *SUBJECT TO AMENDMENT*
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. *WITHOUT NOTICE*
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID. *SPRAY PAINT*
WORK ORDER

5) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 25614 B



UNCONTROLLER, C. O. SUBJECT TO: MIT 4000
D2989-
SHOP, COPY
RETURN TO
ENG. INN. E. R.

25614 B

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DESIGN	DS
CHECKED	
DATE	05.06.07

DRAWN BY	
PH	
APPROVED	#

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SKET LID ASS

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA
REV.
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MBLY 1:1

